

REPRINT



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3015

Job Sheet 206333



Part No: 646.3015

Job Qty: 20 pcs

Part Name: Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 3/9/20

Description:

Type: Stock

Note: DWG REV N/C SHEET 12 IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	20 pcs	3/9/20	3/9/20	0.00	0.31	Bandsaw - 1	ALA
110	HAAS 4 Axis - B4B	20 pcs	3/9/20	3/9/20	0.18	25.09	HAAS - 1 - B4B	ALA / JLM
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
							NV5000 - 1 - B4B	
120	QC 2	20 pcs	3/9/20	3/9/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	ALA / JLM
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	

20-02-02

20-02-02

20-02-02



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 811 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S252739



Part: 646.3015

Job No: 206333

Serial No/Batch: S252739

Revision: Rev NC

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/02/20

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
130	QC 8	20 pcs	3/9/20 0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	5.2.20-02-06
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140	Outsource - 1 - Heat Treat	20 pcs	3/9/20	MEI001-VC	15 2020-02-28
150	Packaging 2-1 - Receive - B4B	20 pcs	3/9/20 0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	MAR 11 2020
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	

				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155	QC 6	20 pcs	3/9/20	0.00 0.00	QC 6 - 9
				QC 6 - 68	DAS
				QC 6 - 61	81
				QC 6 - 40	9-89
				QC 6 - 81	APR 14 2020
160	Spray Paint - 2 - B4B	20 pcs	3/9/20	0.00 0.65	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
162	QC 14	20 pcs	3/9/20	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					QC 14 - 59
					QC 14 - 9
					QC 14 - 68
					QC 14 - 40
					QC 14 - 19
					QC 14 - 43
					QC 14 - 24
					QC 14 - 61
					QC 14 - 81
					QC 14 - 82
180	Packaging 3-1 - Stock - B4B	20 pcs	3/9/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B DAS	
				Packaging 3 - 23 - B4B 84	CCK102
				Packaging 3 - 24 - B4B 9-89	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	20 pcs	3/9/20	0.00 0.00	QC 21 - SA - 21	MAY 19 2020 DAS
				QC 21 - SA - 70	70
				QC 21 - SA - 53	9-89

Part Op 100 - Cut Blank at 6.580"

Descriptions: 110 - 1-Machine per folio FB150

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As per dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL DETAIL OF C OF C REQUIRED

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

160 - (Spray Paint / NDT Room) PRIME AS PER DWG, SEE NOTE #4 5265778

162 - (QC14- Inspect Spray Paint)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	10.9000 ft (.545 ea)	100-Bandsaw - 1	S250217

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MSTEEL-A2-B0.500X1.250	11	11	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.375inches $\pm$ 0.005	0.380 0.370	.376	
2	Blade	0.177inches $\pm$ 0.005 - 0.000	0.182 0.177	.177	Diameter
3	Blade	0.940inches $\pm$ 0.010	0.950 0.930	.938	
4	Blade	0.524inches $\pm$ 0.005	0.529 0.519	.524	
5	Blade	0.240inches $\pm$ 0.020 - 0.002	0.260 0.220	.240	
6	Blade	0.125inches $\pm$ 0.005	0.130 0.120	.125	Radius
7	Blade	45.000Degrees $\pm$ 0.500	45.500 44.500	45°	
8	Blade	0.524inches $\pm$ 0.005	0.529 0.519	.524	
9	Blade	0.690inches $\pm$ 0.002	0.692 0.688	.690	
10	Blade	1.250inches $\pm$ 0.002	1.252 1.248	1.250"	
11	Blade	4.684inches $\pm$ 0.005	4.689 4.679	4.682	
12	Blade	6.450inches $\pm$ 0.010	6.460 6.440	6.440	
13	Blade	0.325inches $\pm$ 0.005	0.330 0.320	.326	
14	Blade	30.000Degrees $\pm$ 0.500	30.500 29.500	30°	

Plex 2/2/20 8:06 AM DART.LAMARCHE.MATHIEU



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045975



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
CN
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045975

PO Date: 2/28/20

Due Date: 3/20/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 30

Freight Terms:

Special Comments:



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204726	D4686-1	D4686 Rev B	Spacer : Various STC's 1 (Outsource process - Heat Treat) HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL	Firmed	-	3/20/20	113 pcs	0 pcs	113 pcs	\$6.2389/pcs	\$705.00



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PURCHASE ORDER

POHB045975



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	206333	646.3015	646.3000 Rev NC	Blade : Various STC's FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As per dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL DETAIL OF C OF C REQUIRED	Firmed X16	-	3/20/20	16 pcs	0 pcs	16 pcs	\$20.9375/pcs	\$335.00

MAR 11 2020

Grand Total: \$1,040.00

Order Notes

Procurement Quality Clauses
A001 right of entry
A002 chemical and physical test report
A003 personnel qualification
A004 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 3/3/20 1:43 PM Dart.Guerin.Kimberley

METCOR INC.

550 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
343393	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
POHB045975	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

HARDNESS

58 - 62 HRC

5

60 - 61 HRC

(907)

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
16	7	646.3015 (16) 646.3015 JOB 206333 646.3000 REV NC 1 BOITE DE CARTON

13/3/20

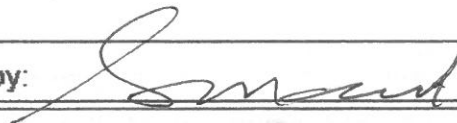
COMMENTAIRES / comments

DAS

81

9-89

APPROUVÉ par / Approved by:



METCOR
7

DATE: 2020-03-07

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
343393	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
POHB045975	N/A	A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	5 (907)	60 - 61 HRC	

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
16	7	646.3015 (16) 646.3015 JOB 206333 646.3000 REV NC 1 BOITE DE CARTON

COMMENTAIRES / comments

VAC HARDEN 1800°F - 1:30 HRS

DOUBLE TEMPER 400°F - 2:00 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
343393	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by:

DATE: 2020-03-10

Lucie Desmarais
QA Technician



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
343393	1	144208

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
POHB045975		A2	2020/2/28	CLIENT

QUANTITÉ	No. PIÈCE /	NOM DE LA PIÈCE /	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight

16 646.3015 7,
(16) 646.3015
JOB 206333
646.3000 REV NC

1 BOITE DE CARTON

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 16
POIDS EXPÉDIÉ / Weight Shipped : 7,00
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

RECEIVED

MAR 11 2020

DART AEROSPACE LTD.

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 16

POIDS EXPÉDIÉ / Weight Shipped : 7,00

Signature:

Date: